

731-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:38:46 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MECHANICAL GROUND HANDLING WHEEL KIT
Job Number : 47362B	
Estimate Number : 12140	
P.O. Number :	Part Number : D206731042
This Issue : 22/04/2009 S.O. No. :	Drawing Number : DSK 093 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 45681B	Material :
Written By :	Due Date : 05/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUL 09-04-22</u>	
Comment : : est rev. A 01.02.01 new issue EC Est Rev:B As per Rev b 07-02-13 JLM est rev C 07.05.14 rev C IIN ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	B44058

SAD 09-05-14

✓ 2.0	D3353042	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3353-042	LUG ARM WELDMENT	47616

SAD 09-05-14

✓ 3.0	D3354042	Mirror Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-042	Left Arm Weldment	B40160

SAD 09-05-14

✓ 4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RIGHT ARM WELDMENT

batch: B36639

SAD 09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 47362B

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	D3356-1	pin

batch

B44575

SAD 09-05-14

6.0

D3397041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	D3397-041	Wheel ass'y

batch

47618-1

SAD 09-05-14

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	113-800	GREASE FITTING

batch

M109654

SAD 09-05-14

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	656-051	flat washer

batch

105735

SAD 09-05-14

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	663-079	Lock washer

batch

~~M111079~~
M16362

SAD 09-05-14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 47362B

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	M19278

SAD 09-05-14

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	M110523

SAD 09-05-14

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	CP-21	1/8" Cotter Pin 2" long	M108200

SAD 09-05-14

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	M109840

SAD 09-05-14

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	M111550

SAD 09-05-14

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Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

M16538

SAD 09-05-14
~~09-05-15~~

✓ 16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

M16362

SAD 09-05-14

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

SAD 09-05-14

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/05/15

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PDP47362

SAD 09/05/15

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 09-05-15

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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